

Date: Monday, 6/12/2006 3:19:39 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 02.750 SUPPORT
Job Number	: 27475		
Estimate Number	: 10829		
P.O. Number	: N/A	Part Number	: D28931
This Issue	: 6/12/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2893 REV A1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25657	Drawing Revision	: A1
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 6/30/2006
Checked & Approved By	: <u>[Signature]</u> 06.06.13	Qty:	30 Um: Each
Comment	: Est: C 02.11.26 Reformat; Added P/O KJ est D 06.04.19 removed alodine EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1572

C 206128/06 (30)

Description: D6104-005

Material: 17-4 PH-SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required

2.0	D6104005	17-4 SS Roundbar 4.00"OD
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)  
 Support

QC6 BG 06.07.17 30

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

06/7/13 (30)

4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn blank for Haas as per Folio FA081

BG / MS 06/08/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/09/06

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/12/2006 3:19:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 27475

Part Number: D28931

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SG/MS

06/08/11

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: BAND SAW

Machine as per Folio FA081

Tumble & Deburr

3.6/5

06/07/31

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT ALL DIM TO DIM SHEET

3.6/5

06/08/04

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD

06.08.14

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/08/15

30

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AL 06/08/16

30

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5166

PD

AL 06/08/16

30

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.22

Job Completion



C206/08/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27475
<b>Description:</b> Ø2.750 Support	<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893 Rev. A1	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712		2.712	2.711	2.712	2.712		
B	4.946	4.966		4.947	4.953	4.952	4.953		
C	3.064	3.084		3.078	3.073	3.078	3.078		
D	0.718	0.738		.732	.731	.730	.730		
E	0.090	0.110		.095	.100	.098	.099		
F	2.934	2.954		2.945	2.943	2.948	2.948		
G	2.166	2.186		2.172	2.173	2.172	2.171		
H	3.890	3.910		3.900	3.900	3.900	3.900		
I	0.914	0.934		.920	.920	.920	.920		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.119	.119	.121	.119		
L									
HAAS Section									
AA	2.985	3.005		2.996	2.999	2.997	2.994		
AB	0.440	0.460		0.460	0.450	0.450	0.450		
AC	0.125	0.160		0.150	0.140	0.133	0.144		
AD	0.040	0.060		0.055	0.043	0.042	0.047		
AE	0.188	0.193	DT8706	0.193	0.188	0.188	0.188		
AF	0.125	0.160		0.135	0.134	0.140	0.141		
AG	0.140	0.160		0.154	0.151	0.148	0.145		
AH	1.360	1.400		1.369	1.380	1.377	1.380		
AI	0.040	0.060		0.049	0.051	0.051	0.052		
AJ	1.190	1.230		1.215	1.223	1.221	1.222		
AK	0.010	0.020		0.015	0.015	0.015	0.015		
AL	0.053	0.073		0.063	0.063	0.063	0.063		
AM	0.240	0.260		0.250	0.250	0.250	0.250		
AN	2.518	2.538		—	N/A	N/A	N/A		
AO	84.39	90.39	DT8699	—	N/A	N/A	N/A		
AP	0.257	0.262	DT8683	0.258	0.257	0.257	0.257		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR									
AS									
Accept/Reject									

Measured by: MS / S-G / En RBG	Audited by: Jnl
Date: 06/01/20 / 06/08/01	Date: 06/08/01

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	#

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 27475
<b>Description:</b> Ø2.750 Support		<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893 Rev. A1		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 #	6 #	7 #	8 #	By	Date
<b>Lathe Section</b>									
A	2.707	2.712		2.712	2.712	2.712	2.711		
B	4.946	4.966		4.953	4.953	4.952	4.955		
C	3.064	3.084		3.080	3.075	3.074	3.075		
D	0.718	0.738		.730	.730	.730	.730		
E	0.090	0.110		.100	.100	.098	.097		
F	2.934	2.954		2.949	2.945	2.944	2.945		
G	2.166	2.186		2.170	2.165	2.168	2.169		
H	3.890	3.910		3.900	3.900	3.900	3.901		
I	0.914	0.934		.920	.920	.920	.924		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.120	.119	.118	.117		
L									
<b>HAAS Section</b>									
AA	2.985	3.005		2.996	2.996	2.995	2.998		
AB	0.440	0.460		0.450	0.450	0.450	0.450		
AC	0.125	0.160		0.135	0.138	0.136	0.139		
AD	0.040	0.060		0.048	0.044	0.043	0.045		
AE	0.188	0.193	DT8706	0.180	0.188	0.188	0.188		
AF	0.125	0.160		0.144	0.135	0.132	0.139		
AG	0.140	0.160		0.148	0.146	0.147	0.148		
AH	1.360	1.400		1.382	1.378	1.376	1.378		
AI	0.040	0.060		0.049	0.047	0.047	0.048		
AJ	1.190	1.230		1.223	1.218	1.215	1.219		
AK	0.010	0.020		0.015	0.015	0.015	0.015		
AL	0.053	0.073		0.063	0.063	0.063	0.063		
AM	0.240	0.260		0.250	0.250	0.250	0.250		
AN	2.518	2.538		N/A	N/A	N/A	N/A		
AO	84.39	90.39	DT8699	N/A	N/A	N/A	N/A		
AP	0.257	0.262	DT8683 0.257	0.257	0.257	0.257	0.257		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR									
AS									
<b>Accept/Reject</b>									

Measured by: J.G/EP/MS/BG
Date: 06108103

Audited by: SD
Date: 06.08.09

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	#

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27475
<b>Description:</b> Ø2.750 Support	<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893 Rev. A1	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 <sup>th</sup>	10 <sup>th</sup>	11 <sup>th</sup>	12 <sup>th</sup>	By	Date
Lathe Section									
A	2.707	2.712		2.712	2.712	2.712	2.712		
B	4.946	4.966		4.951	4.950	4.950	4.953		
C	3.064	3.084		3.074	3.074	3.074	3.074		
D	0.718	0.738		.733	.730	.730	.730		
E	0.090	0.110		.095	.098	.100	.099		
F	2.934	2.954		2.944	2.944	2.944	2.944		
G	2.166	2.186		2.176	2.175	2.175	2.175		
H	3.890	3.910		3.900	3.900	3.898	3.899		
I	0.914	0.934		.928	.930	.931	.930		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.115	.117	.116	.117		
L									
HAAS Section									
AA	2.985	3.005		2.998	2.996	2.995	2.998		
AB	0.440	0.460		0.450	0.451	0.450	0.459		
AC	0.125	0.160		0.138	0.137	0.138	0.139		
AD	0.040	0.060		0.040	0.040	0.040	0.048		
AE	0.188	0.193	DT8706	0.188	0.188	0.188	0.188		
AF	0.125	0.160		0.139	0.138	0.137	0.139		
AG	0.140	0.160		0.147	0.147	0.146	0.147		
AH	1.360	1.400		1.379	1.378	1.377	1.377		
AI	0.040	0.060		0.048	0.047	0.048	0.047		
AJ	1.190	1.230		1.220	1.219	1.219	1.214		
AK	0.010	0.020		0.015	0.015	0.015	0.015		
AL	0.053	0.073		0.063	0.063	0.063	0.063		
AM	0.240	0.260		0.250	0.250	0.249	0.249		
AN	2.518	2.538		N/A	N/A	N/A	N/A		
AO	84.39	90.39	DT8699	N/A	N/A	N/A	N/A		
AP	0.257	0.262	DT8683	0.258	0.258	0.257	0.258		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR									
AS									
Accept/Reject									

Measured by: J.G. / M.S. / B.K.	Audited by: J.D.
Date: 06/08/03	Date: 06.08.04

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	#

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27475
<b>Description:</b> Ø2.750 Support	<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893 Rev. A1	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13 8	14 2	15 3	16 4	By	Date
<b>Lathe Section</b>									
A	2.707	2.712		2.712	2.712	2.712	2.712		
B	4.946	4.966		4.951	4.952	4.950	4.950		
C	3.064	3.084		3.074	3.074	3.074	3.074		
D	0.718	0.738		.728	.729	.729	.729		
E	0.090	0.110		.102	.102	.105	.102		
F	2.934	2.954		2.944	2.944	2.944	2.944		
G	2.166	2.186		2.175	2.176	2.172	2.172		
H	3.890	3.910		3.900	3.901	3.900	3.900		
I	0.914	0.934		.930	.930	.930	.930		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.125	.120	.119	.117		
L									
<b>HAAS Section</b>									
AA	2.985	3.005		2.998	2.998	2.995	2.996		
AB	0.440	0.460		0.459	0.450	0.450	0.450		
AC	0.125	0.160		0.138	0.141	0.132	0.139		
AD	0.040	0.060		0.048	0.049	0.048	0.045		
AE	0.188	0.193	DT8706	0.188	0.188	0.188	0.188		
AF	0.125	0.160		0.139	0.134	0.140	0.133		
AG	0.140	0.160		0.147	0.144	0.146	0.144		
AH	1.360	1.400		1.376	1.378	1.382	1.379		
AI	0.040	0.060		0.047	0.045	0.047	0.048		
AJ	1.190	1.230		1.215	1.213	1.221	1.221		
AK	0.010	0.020		0.015	0.015	0.015	0.015		
AL	0.053	0.073		0.063	0.063	0.063	0.063		
AM	0.240	0.260		0.249	0.250	0.250	0.250		
AN	2.518	2.538		N/A	N/A	N/A	N/A		
AO	84.39	90.39	DT8699	N/A	N/A	N/A	N/A		
AP	0.257	0.262	DT8683	0.258	0.257	0.257	0.257		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR									
AS									
<b>Accept/Reject</b>									

Measured by: J.G. / M.E. / E. / B.	Audited by: S.D.
Date: 06/08/04 06/08/06	Date: 06.08.09

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	J



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27475
<b>Description:</b> Ø2.750 Support	<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893 Rev. A1	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17 <sup>T</sup>	17 <sup>2</sup>	17 <sup>3</sup>	20 <sup>4</sup>	By	Date
Lathe Section									
A	2.707	2.712		2.712	2.712	2.712	2.712		
B	4.946	4.966		4.953	4.956	4.958	4.959		
C	3.064	3.084	3.071	3.071	3.071	3.071	3.071		
D	0.718	0.738	0.721	0.721	0.721	0.721	0.721		
E	0.090	0.110	0.100	0.100	0.100	0.100	0.100		
F	2.934	2.954	2.944	2.944	2.944	2.944	2.944		
G	2.166	2.186	2.172	2.173	2.173	2.173	2.173		
H	3.890	3.910		3.900	3.894	3.896	3.896		
I	0.914	0.934		0.930	0.930	0.930	0.930		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.109	0.129		0.110	0.117	0.110	0.119		
L									
HAAS Section									
AA	2.985	3.005		2.998	2.996	2.999	2.999		
AB	0.440	0.460		0.450	0.450	0.450	0.450		
AC	0.125	0.160		0.134	0.144	0.147	0.146		
AD	0.040	0.060		0.044	0.045	0.046	0.047		
AE	0.188	0.193	DT8706	0.188	0.188	0.188	0.188		
AF	0.125	0.160		0.131	0.132	0.134	0.134		
AG	0.140	0.160		0.146	0.148	0.147	0.146		
AH	1.360	1.400		1.380	1.378	1.379	1.378		
AI	0.040	0.060		0.049	0.048	0.047	0.048		
AJ	1.190	1.230		1.221	1.220	1.221	1.219		
AK	0.010	0.020		0.015	0.015	0.015	0.015		
AL	0.053	0.073		0.063	0.063	0.063	0.063		
AM	0.240	0.260		0.250	0.250	0.250	0.250		
AN	2.518	2.538		N/A	N/A	N/A	N/A		
AO	84.39	90.39	DT8699	N/A	N/A	N/A	N/A		
AP	0.257	0.262	DT8683	0.257	0.257	0.258	0.258		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR									
AS									
Accept/Reject									

Measured by: MS 136 / E / S.G.	Audited by: SD
Date: 06/08/08	Date: 06.08.09

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27475
<b>Description:</b> Ø2.750 Support	<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893 Rev. A1	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
<b>Lathe Section</b>									
A	2.707	2.712		2.712	2.712	2.712	2.712		
B	4.946	4.966		4.951	2.954	2.954	2.954		
C	3.064	3.084		3.074	3.074	3.074	3.074		
D	0.718	0.738		0.724	0.730	0.730	0.730		
E	0.090	0.110		0.101	0.100	0.100	0.100		
F	2.934	2.954		2.944	2.944	2.944	2.944		
G	2.166	2.186		2.172	2.172	2.172	2.172		
H	3.890	3.910		3.896	3.896	3.896	3.896		
I	0.914	0.934		0.930	0.930	0.930	0.930		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.109	0.129		0.114	0.117	0.117	0.117		
L									
<b>HAAS Section</b>									
AA	2.985	3.005		2.999	3.002	3.006	2.998		
AB	0.440	0.460		0.455	0.460	0.450	0.450		
AC	0.125	0.160		0.148	0.150	0.139	0.134		
AD	0.040	0.060		0.045	0.045	0.042	0.043		
AE	0.188	0.193	DT8706	0.188	0.188	0.188	0.188		
AF	0.125	0.160		0.132	0.138	0.131	0.140		
AG	0.140	0.160		0.147	0.146	0.144	0.149		
AH	1.360	1.400		1.384	1.375	1.376	1.380		
AI	0.040	0.060		0.044	0.044	0.041	0.043		
AJ	1.190	1.230		1.220	1.216	1.208	1.215		
AK	0.010	0.020		0.015	0.015	0.015	0.015		
AL	0.053	0.073		0.063	0.063	0.063	0.063		
AM	0.240	0.260		0.250	0.250	0.250	0.250		
AN	2.518	2.538		N/A	N/A	N/A	N/A		
AO	84.39	90.39	DT8699	N/A	N/A	N/A	N/A		
AP	0.257	0.262	DT8683	0.257	0.258	0.257	0.257		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR									
AS									
<b>Accept/Reject</b>									

Measured by:	J.G MB / EP 186
Date:	06/08/09 / 06/08/10

Audited by:	SA
Date:	06.08.14

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27475
<b>Description:</b> Ø2.750 Support	<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893 Rev. A1	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712		2.712	2.712	2.712	2.711		
B	4.946	4.966		4.955	4.955	4.955	4.952		
C	3.064	3.084		3.084	3.084	3.084	3.084		
D	0.718	0.738		.730	.730	.730	.730		
E	0.090	0.110		.100	.100	.100	.100		
F	2.934	2.954		2.944	2.944	2.944	2.944		
G	2.166	2.186		2.176	2.176	2.176	2.176		
H	3.890	3.910		3.900	3.900	3.903	3.899		
I	0.914	0.934		.925	.925	.920	.924		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.119	.119	.119	.122		
L									
HAAS Section									
AA	2.985	3.005		2.997	2.996	2.995	2.996		
AB	0.440	0.460		0.450	0.450	0.450	0.450		
AC	0.125	0.160		0.136	0.132	0.135	0.140		
AD	0.040	0.060		0.042	0.043	0.044	0.047		
AE	0.188	0.193	DT8706	0.188	0.188	0.188	0.188		
AF	0.125	0.160		0.135	0.132	0.132	0.135		
AG	0.140	0.160		0.150	0.148	0.149	0.148		
AH	1.360	1.400		1.383	1.380	1.381	1.384		
AI	0.040	0.060		0.042	0.045	0.050	0.047		
AJ	1.190	1.230		1.221	1.220	1.225	1.225		
AK	0.010	0.020		0.015	0.015	0.015	0.015		
AL	0.053	0.073		0.063	0.063	0.063	0.063		
AM	0.240	0.260		0.250	0.250	0.250	0.250		
AN	2.518	2.538		N/A	N/A	N/A	N/A		
AO	84.39	90.39	DT8699	N/A	N/A	N/A	N/A		
AP	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR									
AS									
Accept/Reject									

Measured by:	EP / MS / BG
Date:	06/08/11

Audited by:	SD
Date:	06.08.11

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27475
<b>Description:</b> Ø2.750 Support	<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893 Rev. A1	<b>Page 1 of 1</b>

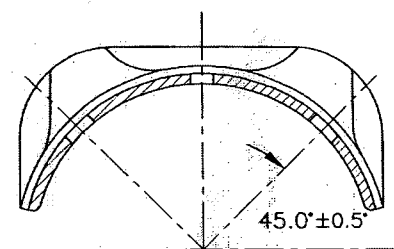
Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
<b>Lathe Section</b>									
A	2.707	2.712		2.712	2.710				
B	4.946	4.966		4.952	4.951				
C	3.064	3.084		3.074	3.074				
D	0.718	0.738		.730	.730				
E	0.090	0.110		.100	.100				
F	2.934	2.954		2.944	2.944				
G	2.166	2.186		2.176	2.176				
H	3.890	3.910		3.900	3.900				
I	0.914	0.934		.920	.920				
J	0.022	0.042		.032	.032				
K	0.109	0.129		.119	.120				
L									
<b>HAAS Section</b>									
AA	2.985	3.005		2.986	3.000				
AB	0.440	0.460		.450	0.455				
AC	0.125	0.160		.135	0.138				
AD	0.040	0.060		.050	0.049				
AE	0.188	0.193	DT8706	.188	0.188				
AF	0.125	0.160		.136	0.138				
AG	0.140	0.160		.154	0.156				
AH	1.360	1.400		1.378	1.379				
AI	0.040	0.060		.052	0.054				
AJ	1.190	1.230		1.222	1.219				
AK	0.010	0.020		.015	0.015				
AL	0.053	0.073		.063	0.063				
AM	0.240	0.260		.250	0.250				
AN	2.518	2.538		N/A	N/A				
AO	84.39	90.39	DT8699	N/A	N/A				
AP	0.257	0.262	DT8683	.258	0.258				
AQ	0.053	0.073		.063	0.063				
AR									
AS									
<b>Accept/Reject</b>									

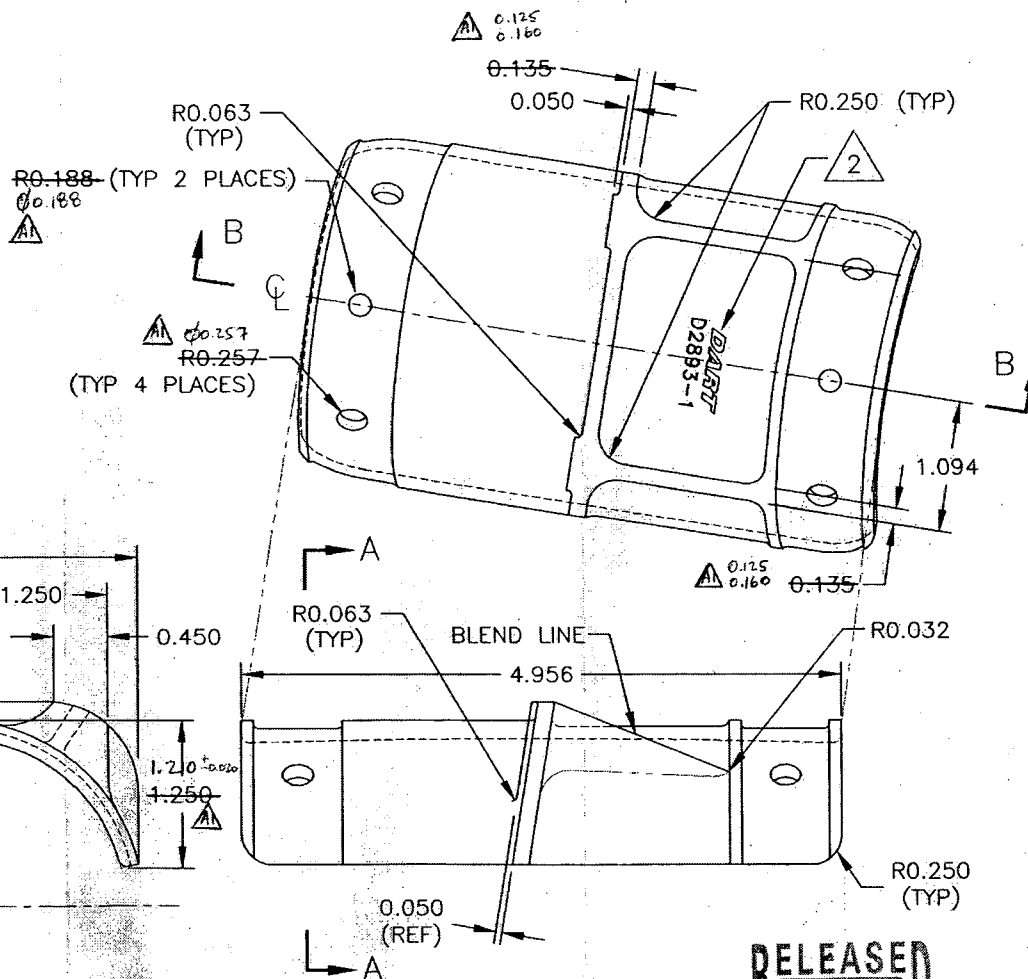
Measured by:	MS / SD
Date:	06.08.13

Audited by:	S.G
Date:	06/08/14

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	#



SECTION A-A  
TOOLING HOLE DETAIL



D2893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN  
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 015 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27475

RELEASE  
01.01.11

A1 <b># CP</b> 02.01.23		UPDATE DIMS AS MANUFACTURED.		C200	
A 01.01.10		NEW ISSUE			
DESIGN <b>CP</b>	DRAWN BY <b>CP</b>	<b>DART</b>		DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA	
CHECKED <b>RF</b>	APPROVED <b>#</b>	DRAWING NO. <b>D2893</b>		REV. A	
DATE <b>01.01.10</b>		TITLE <b>02.750 SUPPORT</b>		SHEET 1 OF 1	
				SCALE 1:1	

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OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

# COPPER AND BRASS SALES

MATERIAL TYPE  
STAINLESS STEEL

D2893-1  
w/o # 27475

AISI SERIES  
200 300 400  
AND  
PRECIPIT HARDENING GRADES

## "WARNING"

INHALATION OF FUMES, FRESHLY GENERATED BY THE WELDING OF STAINLESS STEEL CONTAINING ONE OR MORE OF THE FOLLOWING INGREDIENTS, ZINC, MAGNESIUM OR COPPER, ARE KNOWN TO CAUSE METAL FUME FEVER. INHALATION OF DUST OR FUME FROM STAINLESS STEEL CONTAINING ONE OR MORE OF THE FOLLOWING INGREDIENTS, ALUMINUM, IRON, MANGANESE, SELENIUM, OR TIN, HAS ALSO BEEN REPORTED TO CAUSE METAL FUME FEVER AND MAY CAUSE IRRITATION TO THE RESPIRATORY TRACT AND/OR AGGRAVATE PRE-EXISTING CONDITIONS. TARGET ORGAN IS PRIMARILY THE LUNG.

THIS PRODUCT CONTAINS CHROMIUM. EXPOSURE TO CHROMIUM DUST OR FUME MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS AND KIDNEY AND LIVER DAMAGE. UNDER HIGH TEMPERATURES, HEXAVALENT CHROMIUM MAY BE PRODUCED, IF IN THE INSOLUBLE FORM, IT IS A CONFIRMED HUMAN CARCINOGEN. THIS PRODUCT MAY ALSO CONTAIN NICKEL AND COBALT. INHALATION OF NICKEL OR COBALT DUST OR FUME MAY RESULT IN INFLAMMATION OF THE RESPIRATORY TRACT. NICKEL AND COBALT HAVE BEEN IDENTIFIED AS POTENTIAL HUMAN CARCINOGENS.

IF COATED WITH OIL, MAY CAUSE SKIN IRRITATION/DERMATITIS BY CONTACT. WELDING FUME IS LISTED AS A POSSIBLE CARCINOGENIC TO HUMANS.

READ THE STAINLESS STEEL MATERIAL SAFETY DATA SHEET (MSDS) ON FILE WITH YOUR EMPLOYER BEFORE WORKING WITH THIS MATERIAL

- \* If processing or recycling produces particulate, use exhaust ventilation or other controls designed to prevent exposure to workers. Examples of such activities include melting, welding, grinding, abrasive sawing, sanding and polishing. Any activity which abrades the surface of this material can generate airborne particulate. Use respiratory protection (P100, quantitative fit testing required) if exposures exceed the permissible limits.
- \* The Occupational Safety and Health Administration (OSHA) have set mandatory limits on occupational exposures.
- \* Stainless Steel, in solid form and as contained in finished products presents no special health risk.
- \* Sold for manufacturing purposes only. This product can be recycled; contact your sales representative.

The Occupational Safety and Health Administration require employers to provide training in the proper use of this product.

For additional information, call or write to Copper and Brass Sales, 22355 West Eleven Mile Road, Southfield, MI 48033, telephone 248-233-5600, or visit our web site @ [www.copperandbrass.com](http://www.copperandbrass.com).

**VALBRUNA**

SLATER STAINLESS, INC.  
2400 Taylor Street West, P.O. Box 630  
Fort Wayne, Indiana USA 46801  
Phone: 260-434-2892 Fax: 260-434-2905

**Product Certification Report****Report Number: 4154470****Certified on Mar 15, 2006 Page 1 of 1**

Order I.D. <b>0600370 001</b>		Order Date <b>2/09/06</b>		Commodity Code <b>408860-5</b>	
Dim 1 <b>4.0000</b>	Dim 2 <b>.0000</b>	Dim 3 <b>.0000</b>	Heat I.D. <b>241270</b>	Customer I.D. <b>001156</b>	Customer Purchase Order <b>CI8322</b>
Product Shape <b>Rounds</b>			Product Surface <b>HR &amp; Rough Turned</b>		Customer Grade <b>17-4</b>
Length (Inches) <b>132.000 Min. 156.000 Max.</b>			Bill of Lading # <b>402737</b>	Weight	

**Ship To**  
COPPER AND BRASS SALES  
5 STERLING DRIVE  
WALLINGFORD, CT 06492

**Sold To**  
VALBRUNA STAINLESS, INC.  
2400 TAYLOR STREET WEST  
FORT WAYNE, IN 46802

**Lifts: 0043 0044 0045**  
AISI T630

CONDITION A  
~~MAXX-stainless~~  
AMS 5643Q

ASTMA 564-04

**CHEMICAL ANALYSIS**

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	N	Cb	Ta	Cb+Ta
.040	.59	.024	.021	.39	15.50	4.69	.20	3.32	.04	.30	.001	.30

HB  
355

**TENSILE PROPERTIES  
CAPABILITY**

HB	TS (PSI)	.2%YS (PSI)	%EL(2")	%RA	AGE(F)
432	204000	187500	13.4	51.1	900

**MAGNETIC PARTICLE TEST**

FREQ SEV

AVG .00 .00

MACRO ASTM E340/E381

MACRO  
OK  
OK  
OK

**PERCENT FERRITE**

% FERRITE

AVG .0

Free of mercury and low melting alloy contamination.

MAXX stainless.

Chemical testing performed to one or several of the following ASTM methods: E415, E572, E1019, E1085, E1086.

Material melted in Italy, manufactured in the United States.

Material conforms to listed specifications.

Quality system is compliant with ISO 9001:2000. Produced in accordance with EN 10204 3.1B.

Results relate only to the items tested. Certification shall not be reproduced except in full, without written approval of Valbruna Stainless Inc. The recording of false, fictitious, or fraudulent statements on this document may be punished as a felony under federal statutes, including Federal law, Title 18, Chapter 47. Consult material safety data sheet (MSDS) for hazard info. I hereby certify that the reported figures are correct as contained in the records of the corporation.

Manager Laboratory Services

*Dennis Hackett*  
Dennis Hackett

1944  
MAY  
15



# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 27475

Part Number: D28931

REFERENCE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*PC / MS*

*06/08/11*

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: *BAND SAW*

*Haas*  
Machine as per Folio FA081  
Tumble & Deburr

*S.G / En*

*06/07/31*

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT ALL DIM TO DIM SHEET

*S.G / En*

*06/08/04*

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*SD*

*06.08.14*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*YH*  
*DC*

*07/01/16*

*06/08/15*

*30*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*07/01/16*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *51166*

*07/01/16*

*07/01/16*

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



*cat fish*  
*snakes of a phgr*